

Work Order ID 134768

Monday, July 20, 2015 1:58:02 PM

134768

Ship tomorrow Page 1

Item ID: D044-662-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: R44 Bearpaw Wearplates
 Start Date: 7/20/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/21/2015 Req'd Qty: 1.00 ***1*** Customer:

Reference:

Approvals: Process Plan: ME Date: 5-7-20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D044-662	E								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD044-662-041		CHG 001						
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

*gave to Marie
ME 5-7-20*

MLJ 15-07-20

JUL 20 2015
DAS
06
9-59

JUL 20 2015
DAS
27
9-59

JUL 20 2015
DAS
06
9-59

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 134768

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Item ID: D044-662-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: R44 Bearpaw Wearplates

Start Date: 7/20/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 7/21/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00					06 06		
130						JUL 20 2015	9-09		
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D044-662-041								
	Location: _____								
	PPP Rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MCS JUL 21 2015

ME
15-7-21

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR-No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

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Work Order ID: 134768

134768

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 7/20/2015

Required Date: 7/21/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-30 JLM
IPP Rev:B As per Ecn 932 & 862 07-03-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2274 *D2274* Radius Block		Manufactured	No			110	Each	185.0000	4	4		DAS 27 9-89	OK
---	--	--------------	----	--	--	-----	------	----------	---	---	--	-------------------	----

DAS
06
9-89

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST	24	
110264	24	
ST006	149	
127579	11	
128474	3	
131031	135	

D2529 *D2529* Washer		Manufactured	No			110	Each	238.0000	4	4		DAS 27 9-89	OK
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DAS
06
9-89

Location	Loc Qty	Loc Code
ST007	237	
131945	237	
ST008	1	
128950	1	

D3565-1 *D3565-1* Wearplate		Manufactured	No			110	Each	5.0000	4	4		DAS 27 9-89	OK
--	--	--------------	----	--	--	-----	------	--------	---	---	--	-------------------	----

DAS
06
9-89

Location	Loc Qty	Loc Code
ST610	5	
130497	5	

DAS
27
JUL 24 2015

DQA: _____ Date: _____



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134768

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 7/20/2015

Required Date: 7/21/2015

Start Qty: 1.00

Required Qty: 1.00

AN4-12A

Purchased

No

110

Each

149.0000

4

AN4-12A

Bolt

DAS

86

9-89

Location

Loc Qty

Loc Code

FG

10

120423

10

ST344

139

m131957

139

**

DAS

27

9-89

AN4-16A

Purchased

No

110

Each

184.0000

4

AN4-16A

Bolt

DAS

86

9-89

Location

Loc Qty

Loc Code

FG

5

121541

5

ST343

179

M132317

179

**

DAS

27

9-89

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134768

Parent Item: D044-662-041

D044-662-041

Parent Item Name: R44 Bearpaw Wearplates

Start Date: 7/20/2015

Required Date: 7/21/2015

Start Qty: 1.00

Required Qty: 1.00

MS21042L4

Purchased

No

110

Each

3,732.000

4

MS21042L4

Locknut

DAS
27
9-89

CR

DAS
06
9-89

Location

Loc Qty

Loc Code

FP001

2

m124231

2

GA

142

m127813

142

ST260a

3408

m129472

8

m130799

56

m131803

6

m132262

338

m132382

3000

ST305

180

m128300

8

m130388

7

m130922

97

m131618

12

m132123

56

4

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**WORK ORDER NON-CONFORMANCE / UPDATE**

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Misidentified ☐	Past Due ☐																																																																

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D044-662-011 Bearpaw Installation	4.6 lb 2.10 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.1 in 3.25 m	589 in-lb 6.8 m-kg
D044-662-013 Bearpaw Installation	6.2 lb 2.81 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	129.1 in 3.28 m	800 in-lb 9.2 m-kg
D044-662-041 Wearplate Kit (Installed on D044-662-011/-013 Bearpaw Kit)*	1.6 lb 0.73 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	128.3 in 3.26 m	205 in-lb 2.4 m-kg

*D044-662-041 weight and balance should be added to D044-662-011/-013 kits

5.0 PARTS LIST

Qty -011	Qty -013	Qty -041	Part Number	Description
X			D044-662-011	BEARPAW INSTALLATION
	X		D044-662-013	BEARPAW INSTALLATION
		X	D044-662-041	WEARPLATE KIT
		4	D2274	Radius Block
8	8	4	D2529	Washer
2			D3075-1	Bearpaw
	2		D3529-1	Bearpaw
4	4		D3556-1	Clamp
		4	D3565-1	Wearplate
8	8		D3601-1	Radius Block
4	4		D4953-1	Cushion (Replaces D2182B045 Cushion)
		4	AN4-12A	Bolt
4	4		AN4-14A	Bolt
4	4		AN4-15A	Bolt
		4	AN4-16A	Bolt
8	8		NAS1149D0463J	Washer (Replaces AN960JD416 Washer)
8	8	4	MS21042L4	Nut (or MS21042-4)